

Work Order ID 85052

85052

Page 1

May-31-12 3:41:53 PM

Item ID: D206-802-031

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Passenger Door Opener Installation, LH

Start Date: 31/05/2012 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 14/06/2012 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: *ML5*

Date: *12/06/01* Tooling:

Date:

Run Start *NR1*

QC:

Date: SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

IIN-D407-802-3

A

100

100

DC

Document Control

DOCUMENT CONTROL

Memo

Photocopy bluefile and create labels per PPP D206-802-031 CHG001

0.00

0.00



17/10/09

002

12/10/09 ML5 12-10-3

105

105

Packaging

Packaging

Pick Kit

Memo

0.00

0.00

12/10/09



110

110

QC

Quality Control

QC4- 100% Inspect kits for completeness

Memo

0.00

0.00



17/10/09



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Stop *NS2*

Start Date: 31/05/2012 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 14/06/2012 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run Start *NR1*
	QC:	Date:	SPC (Y/N):	Date:	Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	Packaging	0.00							
120									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPPDD206-802-031								
	Location: 21								
	PPP rev:								
130	QC21- Final Inspection - Work Order Release	0.00							
130									
QC	Memo	0.00							
Quality Control									

H 12-10-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

May-31-12 3:41:57 PM

Page 1

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Parent Item: D206-802-031

D206-802-031

Parent Item Name: Passenger Door Opener Installation, LH

Start Date: 31/05/2012

Required Date: 14/06/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 10.12.03 as per dwg rev.A DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D3552-17

Manufactured No

105 Each 17.0000

D3552-17

Door Prop

** 288 100 sel

Location

Loc Qty

Loc Code

ST272

15

64338

4

65120

1

83585

10

ST276

2

69670

2

D3622-5

Manufactured No

105 Each 40.0000

D3622-5

Ball Stud

** 2 sel

Location

Loc Qty

Loc Code

ST058

40

80406

10

82314

30

D4115-5

Manufactured No

105 Each 0.0000

D4115-5

Doubler

D4115-041

Manufactured No

105 Each 1.0000

D4115-041

Litter Door Bracket Assembly

** 1 sel

** 1 sel 12/10/13

Location

Loc Qty

Loc Code

ST098

1

64504

1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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May-31-12 3:41:57 PM

Page 2

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Parent Item: D206-802-031

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Parent Item Name: Passenger Door Opener Installation, LH

Start Date: 31/05/2012

Required Date: 14/06/2012

Start Qty: 1.00

Required Qty: 1.00

CR3242-5-4

Purchased

No

105

Each

84.0000

3

CR3242-5-4
Rivet

**

Location

Loc Qty

Loc Code

ST332

84

116583

84

CR3243-5-4

Purchased

No

105

Each

93.0000

2

CR3243-5-4
Rivet

**

Location

Loc Qty

Loc Code

ST332

93

116583

93

MS20426AD4-5

Purchased

No

105

Each

4,731.000

2

MS20426AD4-5
Rivet

**

Location

Loc Qty

Loc Code

ST317

4731

6874

4731

MS20600-AD4W2

Purchased

No

105

Each

209.0000

9

MS20600-AD4W2
Rivet

**

Location

Loc Qty

Loc Code

ST321

209

116391

5

116471

4

116805

4

117601

1

117885

10

119638

3

120142

82

121011

100

May-31-12 3:41:57 PM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Parent Item: D206-802-031

Parent Item Name: Passenger Door Opener Installation, LH

85052

D206-802-031

Start Date: 31/05/2012

Required Date: 14/06/2012

Start Qty: 1.00

Required Qty: 1.00

MS2107315

Purchased

No

105

Each

32.0000

**

1

MS210731 5

nut plate

Location

Loc Qty

Loc Code

ST302

2

117395

2

ST303

30

120986

10

121444

20

NAS1149C0532R

Purchased

No

105

Each

279.0000

**

3

NAS1149C0532R

WASHER

Location

Loc Qty

Loc Code

ST297

279

116373

1

116513

51

119736

227

NAS1149C0563R

Purchased

No

105

Each

393.0000

**

3

NAS1149C0563R

Washer

Location

Loc Qty

Loc Code

ST296

200

120422

200

ST297

193

116391

8

117460

185

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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5.0 PARTS LIST

5.1 D206-802-029/-030 Crew Door Opener Kits

Qty -029	Qty -030	Part Number	Description
1	1	D206-802-029	CREW DOOR OPENER KIT, LH
1	1	D206-802-030	CREW DOOR OPENER KIT, RH
1	1	D3552-15	DOOR PROP
1	1	D3622-5	BALL STUD
1	1	D4110-3	DOUBLER, SILL
1		D4114-1	DOOR DOUBLER, LH
	1	D4114-2	DOOR DOUBLER, RH
4	4	MS20426AD4-5	RIVET
32	32	MS20600AD4W2	RIVET
2	2	MS21073L5	ANCHOR NUT
1	1	MS27130-A26	RIVNUT
6	6	NAS1149C0532R	WASHER
6	6	NAS1149C0563R	WASHER

5.2 D206-802-031/-032 Passenger Door Opener Kits

Qty -031	Qty -032	Part Number	Description
1	1	D206-802-031	PASSENGER DOOR OPENER KIT, LH
1	1	D206-802-032	PASSENGER DOOR OPENER KIT, RH
1	1	D3552-17	DOOR PROP
1	2	D3622-5	BALL STUD
	1	D4112-1	AFT SILL DOUBLER
1	1	D4115-5	DOUBLER
		D4115-041	LITTER DOOR BRACKET ASSY
3		CR3242-5-4	RIVET
2		CR3243-5-4	RIVET
2	4	MS20426AD4-5	RIVET
9	14	MS20600AD4W2	RIVET
1	2	MS21073L5	ANCHOR NUT
3	6	NAS1149C0532R	WASHER
3	6	NAS1149C0563R	WASHER

Change Record

PAGE 1 OF 1

Part Number: D206-802-031

Description: PASSENGER DOOR OPENER, LH

[illegible]